

Date: Friday, 5/25/2007 8:16:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLEVIS
 Job Number : 32587
 Estimate Number : 10773
 P.O. Number : *N/A*
 This Issue : 5/25/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *ML* Type : SMALL /MED FAB
 Previous Run : 28109
 Part Number : D33481
 Drawing Number : D3348 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material : *N/A*
 Due Date : 5/31/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : *07.05.25*
 Comment : Est: A 05.02.09 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S12GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.0191 sf(s)/Unit Total : 0.3822 sf(s)

1010/1025/A21/6aA SHEET

(M1010S12GA) .105" THK

Batch: *m101094*

ml 07 05 25

(20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3348

Dwg Rev: *B*

Prog Rev: *B*

ml 07 05 25

(20)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 05 25

(20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

0705-28 *(20)*
converted.

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

07 06 05 *(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLEVIS

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Part Number: D33481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3348

SP 07/06/05 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

HA 07/06/05 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

David David

HA 07/06/05/20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

SP 07/06/06

Job Completion



U 07/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

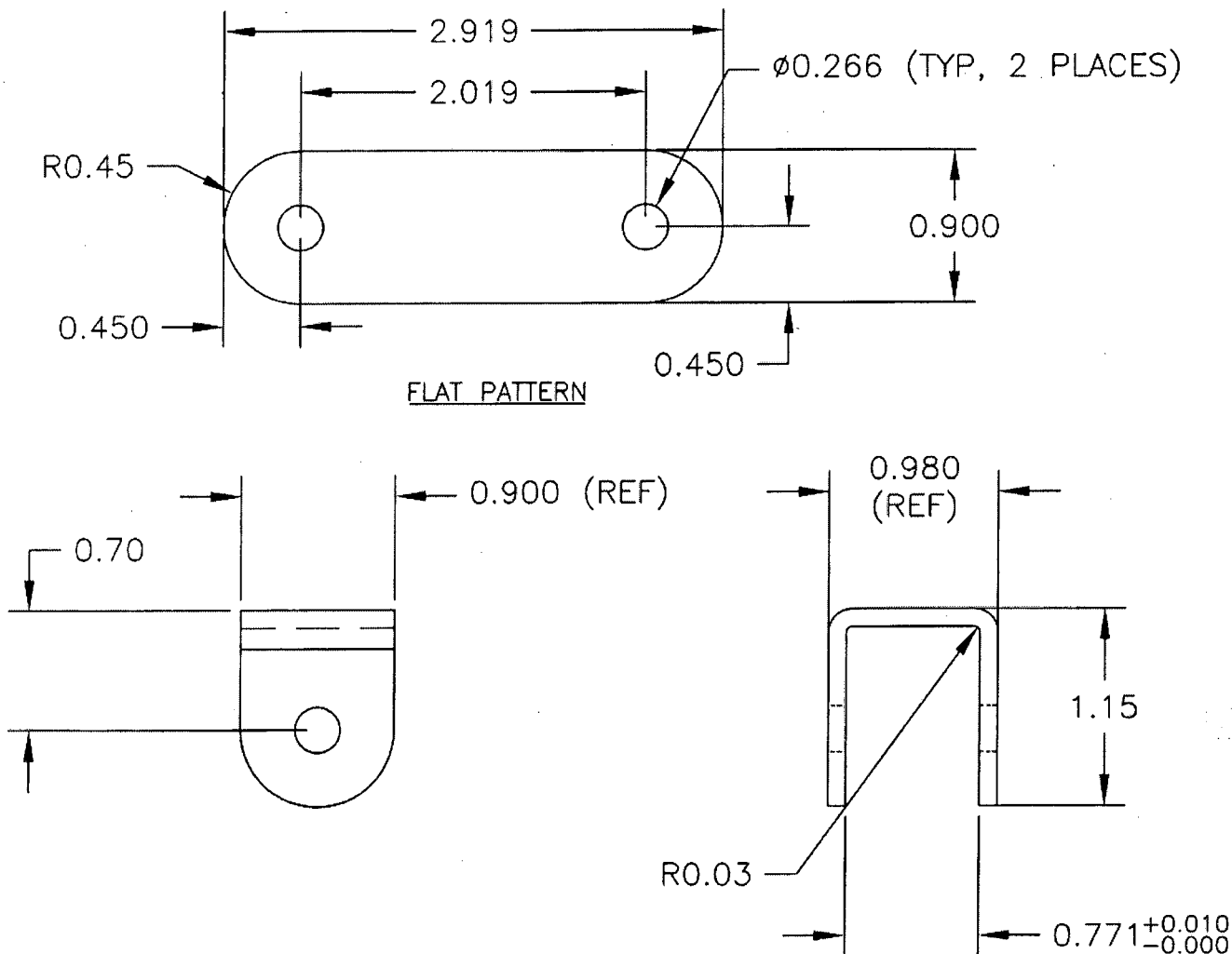
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN FH	DRAWN BY FH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED FH	APPROVED FH	DRAWING NO. D3348	REV. B SHEET 1 OF 1
DATE 05.03.04		TITLE CLEVIS	SCALE 1:1
A	04.11.11	NEW ISSUE	
B	05.03.04	INSIDE RADIUS WAS R0.13, NOW R0.03	

RELEASED
05 03 05



BENDING DETAIL

D3348-1 CLEVIS

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK) (REF DART SPEC. M1010-S12GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE

WORK ORDER
NO. 32581

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